

GEARTECH	QUALITY PROCEDURE	No. QP7000	SHEET 1 OF 2																						
		Rev. A																							
Manufacturing Schedule		BY RLE	DATE	9/06/99																					
		CKD JRM	DATE	9/06/99																					
<p>1. Scope</p> <p>1.1 This procedure covers auditing and approving manufacturing schedules.</p> <p>2. Referenced Documents</p> <p>2.1 AGMA/AWEA 921-A97 Recommended Practices for Design and Specification of Gearboxes for Wind Turbine Generator Systems.</p> <p>2.2 GEARTECH Specifications:</p> <table><tr><td>CK1000</td><td>QP1000</td><td>Procurement process</td></tr><tr><td>CK2000</td><td>QP2000</td><td>Procurement specification</td></tr><tr><td>CK3000</td><td>QP3000</td><td>Bid solicitation and evaluation</td></tr><tr><td>CK5000</td><td>QP5000</td><td>Quality assessment</td></tr><tr><td>CK6000</td><td>QP6000</td><td>Quality assurance plan</td></tr><tr><td>CK7000</td><td>QP7000</td><td>Manufacturing schedule</td></tr><tr><td>CK8000</td><td>QP8000</td><td>Manufacturing audit</td></tr></table> <p>3. Terminology</p> <p>3.1 Manufacturing schedule- See QP5000.</p> <p>3.2 Gantt chart- A list of tasks with a bar chart and timescale showing start and finish dates.</p> <p>4. Significance and Use</p> <p>4.1 Purpose- The manufacturing schedule specifies start and finish dates for significant steps of the manufacturing process including hold and witness points (see QP6000).</p> <p>4.2 Manufacturing audit- The manufacturing schedule informs manufacturer and purchaser of the sequence of manufacturing and schedules quality assurance inspections and tests.</p> <p>5. Procedure</p> <p>5.1 Responsibilities- The manufacturing schedule shall be designed and maintained by the gear manufacturer. The gear manufacturer shall assign a contact person with adequate time and resources to provide timely progress reports. The purchaser shall audit the manufacturing schedule to ensure that it is adequate to achieve quality goals. The purchaser's representative shall be responsible for witnessing inspections and tests defined by hold and witness points (see QP8000).</p> <p>5.2 Preliminary manufacturing schedule- During bid solicitation and evaluation, bidders may submit a preliminary manufacturing schedule in accordance with QP3000. However, the final manufacturing schedule shall be the responsibility of the gear manufacturer.</p> <p>5.3 Final manufacturing schedule- During bid solicitation and evaluation, bidders shall propose a deadline for the final manufacturing schedule (see QP3000). The purchaser shall enforce the deadline.</p> <p>5.4 Manufacturing schedule audit- The purchaser and gear specialist shall audit the manufacturing schedule for conformance to the procurement specification. See CK7000 for required content of the manufacturing schedule. See QP2000 for guidelines for</p>					CK1000	QP1000	Procurement process	CK2000	QP2000	Procurement specification	CK3000	QP3000	Bid solicitation and evaluation	CK5000	QP5000	Quality assessment	CK6000	QP6000	Quality assurance plan	CK7000	QP7000	Manufacturing schedule	CK8000	QP8000	Manufacturing audit
CK1000	QP1000	Procurement process																							
CK2000	QP2000	Procurement specification																							
CK3000	QP3000	Bid solicitation and evaluation																							
CK5000	QP5000	Quality assessment																							
CK6000	QP6000	Quality assurance plan																							
CK7000	QP7000	Manufacturing schedule																							
CK8000	QP8000	Manufacturing audit																							

procurement specifications.

GEARTECH	QUALITY PROCEDURE	No. QP7000	SHEET 2 OF 2	
		Rev. A		
Manufacturing Schedule		BY RLE	DATE	9/06/99
		CKD JRM	DATE	9/06/99

- 5.5 Manufacturing schedule approval- Manufacturing shall not begin until the purchaser approves the manufacturing schedule. See QP1000 for guidelines covering the procurement process.
- 5.6 Progress reports- The contact person shall submit progress reports periodically. The manufacturing schedule shall be revised as necessary to make it current with actual progress.
- 5.7 Coordination- The purchaser shall coordinate manufacturing audits with the manufacturing schedule.
6. Acceptance Criteria
- 6.1 Format- The manufacturing schedule shall be a Gantt chart.
- 6.2 Hold and witness points- The manufacturing schedule shall list hold and witness points that are achievable by the purchaser's representative.
- 6.3 Deadlines- The manufacturing schedule shall list completion dates that are compatible with the purchaser's requirements.
7. Report
- 7.1 The purchaser shall write a report that includes recommendations for revisions to the manufacturing schedule required for conformance to the procurement specification.

